## Process Sheet

| | | | |
|---|---|---|---|
| **Customer** | : CU-DAR001 Dart Helicopters Services | **Drawing Name** | : WEB |
| **Job Number** | : 27421 | | |
| **Estimate Number** | : 10482 | | |
| **P.O. Number** | : N/A | **Part Number** | : D2923 |
| **This Issue** | : 6/5/2006    **S.O. No.** : N/A | **Drawing Number** | : D2923 REV.A |
| **Prsht Rev.** | : NC | **Project Number** | : N/A |
| **First Issue** | : N/A    **Type** : LANDING GEAR | **Drawing Revision** | : A |
| **Previous Run** | : 27146 | **Material** | : N/A |
| **Written By** | : SEE COMMENT Below | **Due Date** | : 6/12/2006    **Qty:** 5    **Um:** Each |
| | 91 06.06.05 W | | |
| **Checked & Approved By** | : | | |
| **Comment** | : Est. B 02.07.26 Updated Location RF | | |

**Additional Product**

**Job Number:**

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | D26005108 | Extrusion `I Beam' thin |

**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 1.0000 Each(s)
D2600-5-108 Extrusion `I Beam' thin
Batch: B2Y410    RT 06-06-15 (5)

| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|---|---|---|

**Comment:** LANDING GEAR RESOURCE 1
Cut D2600-5 Extrusion to length as per Dwg D2923.
Deburr ends    JT 06-06-15 (5)

| 3.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|---|---|---|

**Comment:** LANDING GEAR RESOURCE 1
1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481    JT 06-06-15 (5)

2- Open holes to finish size as per Dwg D2923.    JT 06-06-15 (5)

3- Deburr    JT 06-06-15 (5)

| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|---|---|---|

DP 06-6-20 (5)

**Comment:** INSPECT WORK TO CURRENT STEP

| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|---|---|---|

**Comment:** HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1    RT 06-06-20

Form: rprocess

**Dart Aerospace Ltd**

| W/O: | WORK ORDER CHANGES | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | | **By** | **Date** | **Qty** | **Approval** Mfg / Design Mgr | **Approval** QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Design Mgr | **Approval** QC Inspector |
| | | | **Initial** Design Mgr | **Action Description** Design Mgr | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____  PAR #: _____  Fault Category: _____  NCR:  Yes  No  DQA: _____  Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____  Date: _____

H:\forms\Quality Assurance\approved forms\NCRWO revC

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services          **Drawing Name:** WEB

**Job Number:** 27421          **Part Number:** D2923

| Job Number: | |
|---|---|

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |

06-06-20

**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|---|---|---|

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: 44     AT 06-06-21

| 8.0 | DC | DOCUMENT CONTROL |
|---|---|---|

**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion

**Dart Aerospace Ltd**

## WORK ORDER CHANGES

| W/O: | | | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

## WORK ORDER NON-CONFORMANCE (NCR)

| NCR: | | | Corrective Action Section B | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Initial Design Mgr | Action Description Design Mgr | Sign & Date | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____  PAR #: _____  Fault Category: _____  NCR:  Yes  No  DQA: _____  Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____  Date: _____

WORK ORDER NO. 27121
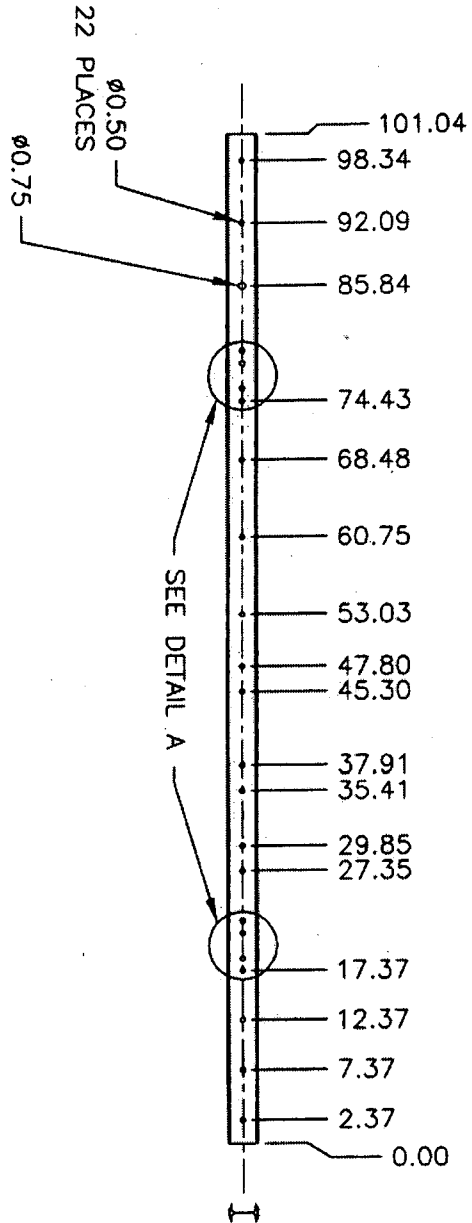
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

MAKE FROM D2600-5 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
REFER TO ENGINEERING COPY

Ø0.50
22 PLACES

Ø0.75

101.04
98.34
92.09
85.84
74.43
68.48
60.75
53.03
47.80
45.30
37.91
35.41
29.85
27.35
17.37
12.37
7.37
2.37
0.00

SEE DETAIL A

DETAIL A
SCALE 1:9

1.250
2.500
1.250

DART

| | DATE | TITLE | SCALE |
|---|---|---|---|
| | 99.10.14 | WEB | 1:18 |
| DESIGN | CHECKED | APPROVED | DRAWING NO. |
| RF | RF | RF | D2923 |
| DRAWN BY | | | SHEET 1 OF 1 |
| RF | | | REV. A |
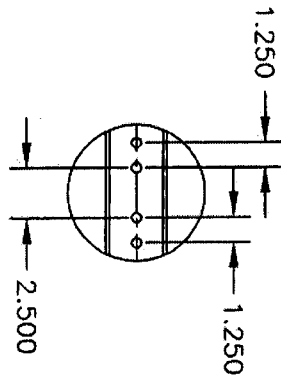
DART AEROSPACE USA, INC.
BELLEVUE, WA

| A | 99.10.14 | NEW ISSUE |
|---|---|---|